

Date: Friday, 04/04/2008 9:23:37 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WEB
Job Number :	38411		
Estimate Number :	12906		
P.O. Number :		Part Number :	D35841
This Issue :	04/04/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3584 REV A
First Issue :	//	Project Number :	N/A
Previous Run :	36935	Drawing Revision :	A
	Type :	Material :	
	LANDING GEAR	Due Date :	11/04/2008
Written By :		Qty:	4 Um: Each
Checked & Approved By :	[Signature] 08.04.4		
Comment :	Est Rev:A New Issue 07.06.12 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2963125	105 I Beam Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 105 I Beam Extrusion 125" Long
 Batch: B28673

~~EL~~ 8-4-10

2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

- 1-Cut to Length as per Dwg D3584
- 2-Drill Pilot Holes using DT8960 Drill Jig
- 3-Open pilots to 1.000" as per Dwg D3584
- 4-Deburr

EL 8-4-10

Tools: Pilot

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

8 04/04/10 (X4)

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

EL 8-4-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 04/04/2008 9:23:37 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB

Job Number: 38411

Part Number: D35841

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 8-4-10

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with part # and Batch then Stock in Landing Gear

Location: SKID tube cell

DP 8-4-10

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/14 J

Job Completion



MF 08-04-11

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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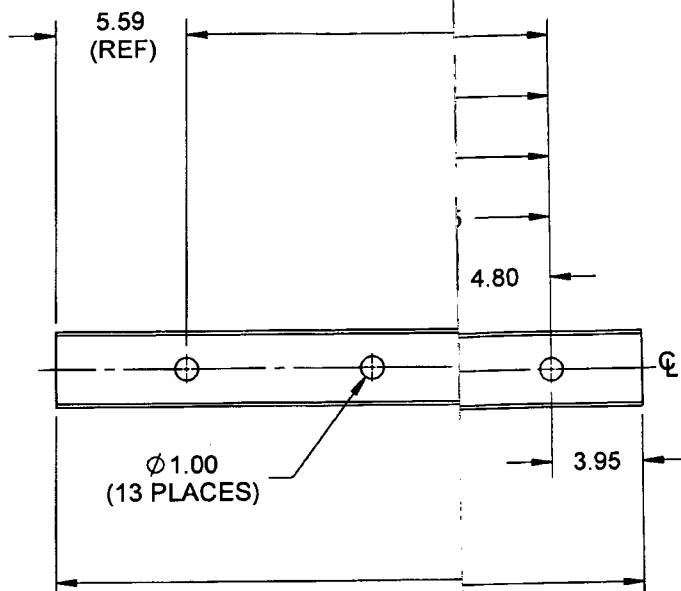
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C

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B

B

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38411

RELEASED
07-11-22

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A

NOTES:

- 1) MATERIAL: MAKE FROM D2963-125 EXTRUS
- 2) FINISH: CHEMICAL CONVERSION COAT PE
- 3) TOLERANCES: PER DART QSI 018 UNLESS
- 4) UNITS: INCHES UNLESS OTHERWISE NOTE
- 5) BREAK SHARP EDGES: 0.010 TO 0.020
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 5.08 lbs

DESCRIPTION	PH	07.06.08
	BY	DATE
DART AEROSPACE USA, INC. PORT HADLOCK, WA		
DRAWING NO.	REV. A	
D3584	SHEET 1 OF 1	
TITLE	SCALE	
WEB	1:8	
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